

WHAT IS CLAIMED IS:

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1. A manufacturing method of a resin molded article having a plurality of clip mounting sections, each of which constructed by erecting a pair of mount ribs having a latched section provided thereon from the back face of a main body, intermittently along a longitudinal direction; the manufacturing method comprising:

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10 employing a lower die that corresponds to a shape of a back side face having the clip mounting section provided thereon and an upper die that corresponds to a shape of a top side face of the resin molded article, wherein the lower die has a stationary section, a first moving section movable relatively to the stationary section, and a secondary moving section movable relatively to the stationary section or the first moving section, and wherein the stationary section or the first moving section has a molding face having provided thereon an undercut portion for molding the latched section;

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20 carrying out injection-molding in a cavity formed by the lower die and upper die, thereby molding the resin molded article;

25 releasing the upper die from the lower die; moving the first moving section, thereby

forming a space inside or outside of a pair of the mount ribs at the clip mounting section; and

moving the second moving section, thereby removing the latched section from the undercut portion while elastically deforming the mount ribs in a direction of the space.

2. A manufacturing method of a resin molded article that has an elongated main body and a plurality of clip mounting sections formed intermittently along a longitudinal direction, each of which is composed of a pair of mount ribs facing to each other, wherein a protrusion protruded outwardly on outside faces that do not face to each other is provided at the tip, the manufacturing method comprising:

employing a lower die that corresponds to a shape of a back side face having the clip mounting section provided thereat and an upper face that corresponds to a shape of a top side face of the resin molded article, wherein the lower die has a stationary section, a first moving section movable relatively to the stationary section in a direction of the upper die, and a second moving section movable relatively to the stationary section to be further distant than movement of the first moving section in the direction of the upper die, and wherein the first moving section has a

molding face having an undercut portion for molding an outside face of the mount rib and the protrusion;

carrying out injection-molding in a cavity formed by the lower die and upper die, thereby molding the resin molded article;

releasing the upper die from the lower die;

moving the first moving section, thereby forming a space between a pair of the mount ribs at the clip mounting section; and

moving the second moving section, thereby removing the protrusion from the undercut portion while elastically deforming the mount rib in a direction of the space.

3. A manufacturing method of a resin molded article that has an elongated main body and a plurality of clip mounting sections formed intermittently along a longitudinal direction, each of which is composed of a pair of mount ribs facing to each other, wherein a protrusion protruded outwardly on outside faces which do not face to each other is provided at the tip, the manufacturing method comprising:

employing a lower die that corresponds to a shape of a back side face at which the clip mounting section is provided and an upper die that corresponds to a shape of a top side face of the resin molded article,

wherein the lower die has a stationary section having a molding face on which an undercut portion for molding the protrusion is provided, a first moving section molding inside faces of the mount ribs face to each other and being movable relatively to the stationary section in a direction opposite to the upper die, and a second moving section movable relatively to the stationary section in a direction of the upper die;

carrying out injection-molding in a cavity formed by the lower die and the upper die, thereby molding the resin molded article;

releasing the upper die from the lower die;

moving the first moving section, thereby forming a space between a pair of the mount ribs at the clip mounting section; and

moving the second moving section, thereby removing the protrusion from the undercut portion while elastically deforming the mount rib in a direction of the space.

4. A clip mounting structure of mounting a clip to a resin molding article having a clip mounting section constructed by erecting a pair of mount ribs from a back face of the main body,

wherein the clip has outer lugs for supporting the mount ribs from the outside and inner lugs for

supporting the mount ribs from the inside, and at either the outer lug or the inner lug has a latch section capable of being latched by a latched section, and

wherein the clip pinches the mount ribs by the outer lugs and the inner lugs, and latches the latch section on the latched section to be mounted on the resin molded article.

5. A clip mounting structure of mounting a clip to a resin molded article in which a pair of mount ribs are erected from a back face of a main body,

wherein the clip has outer lugs for supporting the mount ribs from the outside and inner lugs for supporting the mount ribs from the inside, and , at a tip end of either one of the outer lug and inner lug, has protrusions protruded inwardly and facing to each other,

wherein the mount ribs each has a latch face latched on the protrusion, and

wherein the clip pinches the mount ribs by the outer lugs and the inner lugs, and latches the protrusion on the latch face to be mounted on the resin molded article.

6. A mounting structure of a clip to a resin molded article as claimed in claim 5, wherein, at the mount rib, the latch face is a face at the tip end side of

a through hole inclined so that the size of hole is reduced toward a latch side face at a side facing to the protrusion.

7. A mounting structure of a clip to a resin molded article as claimed in claim 5, wherein the protrusion is provided at the outer lug, and the latch face is latched from the outside of the pair of mount ribs.

8. A mounting structure of a clip to a resin molded article as claimed in claim 5, wherein, at the latch face, an inclined angle between the latch face and the latch side face is 15 to 25 degrees.

9. A mounting structure of a clip to a resin molded article as claimed in claim 5, wherein, at the mount rib, an opposite side face opposed to the latch side face is inclined so that thickness of a root is reduced as compared with the thickness of the tip end of the mount rib.

10. A mounting structure of a clip to a resin molded article as claimed in claim 5, wherein, at the mount rib, the thickness of the root is $1/3$ or less of the thickness of the main body of the resin molded article.

11. A mounting structure of a clip to a resin molded article as claimed in claim 5, wherein tip end faces of the outer lug and the inner lug are inclined at a side in which the tip end faces face to each other.

12. A mounting structure of a resin molded article,
wherein the resin molded article comprise an
elongated main ²¹⁰body and a plurality of clip mounting
sections formed intermittently along a longitudinal
direction, each clip mounting section is composed of
a pair of mount ribs facing to each other, each mount
rib has a protrusion protruded outward of an outside
face that does not face to each other at the tip;

the resin molded article is mounted to a body
panel via a clip corresponding to a position of the
mount ribs,

wherein the clip has a latch claw to be latched
on the protrusion of the mount rib, a slip-proof lug
provided opposite to the latch claw so as not to slip
the latch claw from the protrusion, and an engagement
portion engaged with the body panel at a side opposite
to the body panel; and

the latch claw of the clip is latched at the
protrusion of the mount rib to be mounted to the resin
molded article, and the engagement portion of the clip
is mounted to the body panel, thereby mounting the resin
molded article to the body panel.

13. A mounting structure of a resin molded article as
claimed in claim 12, wherein the mount rib and/or the
latch claw has a position-fixing section for fixing a

position of the clip in the longitudinal direction of the resin molded article.

14. A mounting structure of a resin molded article as claimed in claim 12, wherein a reinforcement rib for improving the strength of the resin molded article is provided at an end in the longitudinal direction of the mount rib, and the reinforcement rib is inclined in the longitudinal direction so that a width between the reinforcement ribs becomes narrow toward the tip end.

15. A mounting structure of a resin molded article as claimed in claim 12, wherein the clip has a reinforcement sections facing to inside faces of the mount ribs facing to each other at a side facing to the resin molded article.

16. A mounting structure of a resin molded article as claimed in claim 12, wherein the clip has a pair of guide sections having an interval equal to or greater than an interval between the protrusions of the pair of the mount ribs at a side facing to the resin molded article, and the guide section protrudes further than the latch claw.

17. A mounting structure of a resin molded article as claimed in claim 12, wherein the pair of the mount ribs each has a groove that corresponds to the width of the clip, the clip is engaged with the groove, and the

position of the clip relevant to the longitudinal direction of the resin molded article is fixed.

18. A mounting structure of a resin molded article as claimed in claim 12, wherein the protrusion comprises a stepped section further protruded outwardly in the vicinity of at least one end in the longitudinal direction.

19. A mounting structure of a resin molded article as claimed in claim 18, wherein an inclined face is provided between the stepped section and the end, wherein a protrusion quantity is gradually reduced as the protrusion is closer from the stepped section to the end.

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